

Work Order ID 70426

Tuesday, June 07, 2011 2:43:27 PM



Page 1

Item ID: D3825-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Basket End)

Start Date: 6/7/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/13/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals:

Process Plan: *Handwritten signature*Date: *11-06-07*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3825	Rev A								

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3825-1 rib as per dwg D3825

2- drill hole (3/16") in D3825-1 using DT9438 jig and open to finish size as per dwg D3825

3- c'sink hole as per dwg

4- remove identification markings

5- deburr

6- weld D2327-3 spacer bushing and D3759-1 bushing as per dwg D3825

A/R S.S. Rod Batch: *M115778*

7- grind bushing weld flush where indicated on dwg D3825

8- deburr if necessary

*SAN 11-06-08**11.06.14**6**6*

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Page 2

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Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PC 11.06.14

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Sub 11.06.14

(46)

150

Identify as per dwg & Stock Location:

WAG

0.00



Packaging

Memo

0.00

Packaging

11.06.14

(6)

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Page 3

Item ID: D3825-041

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Setup Start



Revision ID:

Stop



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Start Date: 6/7/2011 Start Qty: 6.00



Cust Item ID:

Required Date: 6/13/2011 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/15 *[Signature]*
MF
11-06-14

W/O:		WORK ORDER CHANGES						
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

Tuesday, June 07, 2011 2:43:36 PM

Page 1

Work Order ID: 70426

Parent Item: D3825-041

Parent Item Name: Rib Assembly (Basket End)

Start Date: 6/7/2011

Required Date: 6/13/2011

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2327-3 Spacer Bushing		Manufactured	No			100	Each	2.0000	1	6			
<div style="display: flex; justify-content: space-between;"> <u>Location</u> <u>Loc Qty</u> <u>Loc Code</u> </div> <div style="display: flex; justify-content: space-between;"> WA 2 </div> <div style="display: flex; justify-content: space-between;"> 69436 2 </div>													
D3759-1 Bushing		Manufactured	No			100	Each	311.0000	1	6			
<div style="display: flex; justify-content: space-between;"> <u>Location</u> <u>Loc Qty</u> <u>Loc Code</u> </div> <div style="display: flex; justify-content: space-between;"> WA 200 </div> <div style="display: flex; justify-content: space-between;"> 69202 200 </div> <div style="display: flex; justify-content: space-between;"> WA005 111 </div> <div style="display: flex; justify-content: space-between;"> 66489 2 </div> <div style="display: flex; justify-content: space-between;"> 66870 109 </div>													
M304TS0.750W.065 304 SQ Tube .75x.75x.065W		Purchased	No			100	f	998.5073	2.125	13.42105			
<div style="display: flex; justify-content: space-between;"> <u>Location</u> <u>Loc Qty</u> <u>Loc Code</u> </div> <div style="display: flex; justify-content: space-between;"> MAT018 884.6523 </div> <div style="display: flex; justify-content: space-between;"> 117598 806.9536 </div> <div style="display: flex; justify-content: space-between;"> 117636 77.6987 </div> <div style="display: flex; justify-content: space-between;"> WA007 113.8549906 </div> <div style="display: flex; justify-content: space-between;"> 116267 99.549272 </div> <div style="display: flex; justify-content: space-between;"> 116763 14.3057186 </div>													

B70724

6

11.06.14

11.06.14

6

SAD 11-06-08

13.4211

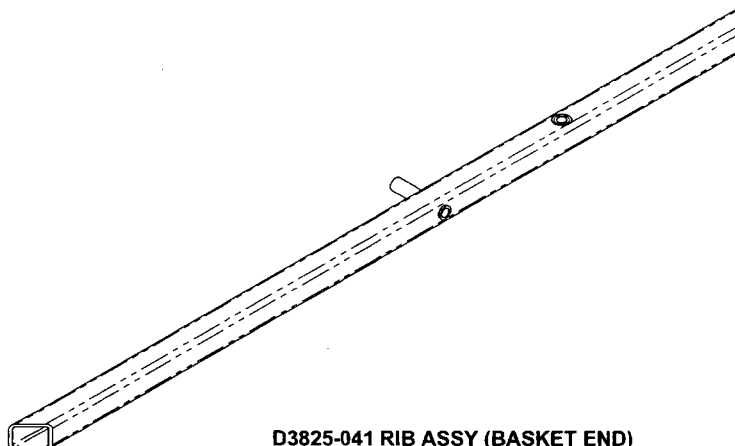
W/O:		WORK ORDER CHANGES						
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			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries



D3825-041 RIB ASSY (BASKET END)

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.22 lbs
 - 8) WELDING: PER DART QSI 004

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D3825-041	RIB ASSEMBLY (BASKET END)
2	1	D2327-3	SPACER BUSHING
3	1	D3759-1	BUSHING
4	1	D3825-1	RIB

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 70424

08-11-06-7

RELEASED
08/11/06

A	NEW ISSUE		MB	08.09.23
REV.		DESCRIPTION	BY	DATE
DESIGN				
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.				
DATE	08.09.23			

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3825** REV. A
SHEET 1 OF 3
TITLE **RIB ASSY (BASKET END)** SCALE NTS

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

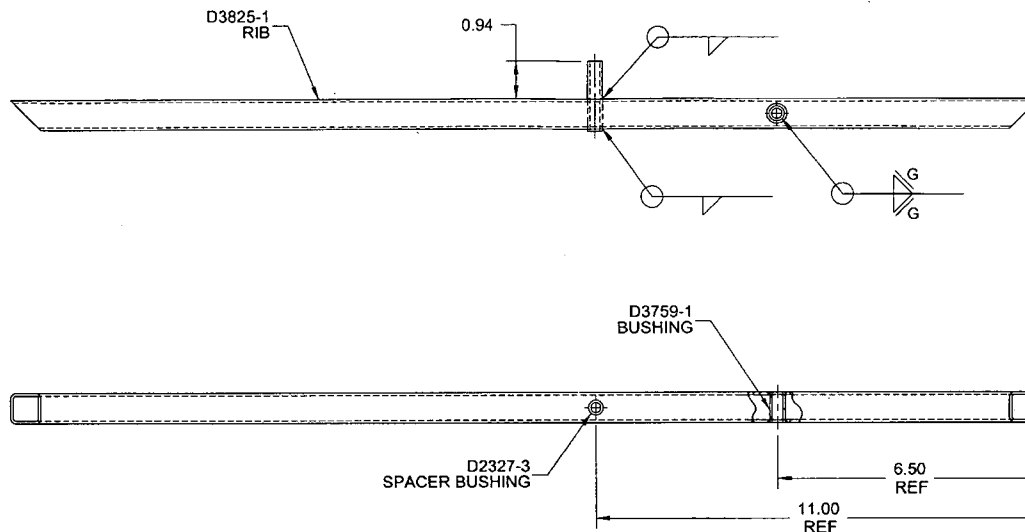
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

W/0 704124



D3825-041 RIB ASSY (BASKET END)

RELEASED
08/11/18 NW

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ADIS	DRAWING NO.	REV. A
MFG. APPR.		D3825	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET END)	
DATE	08.09.23	NTS	
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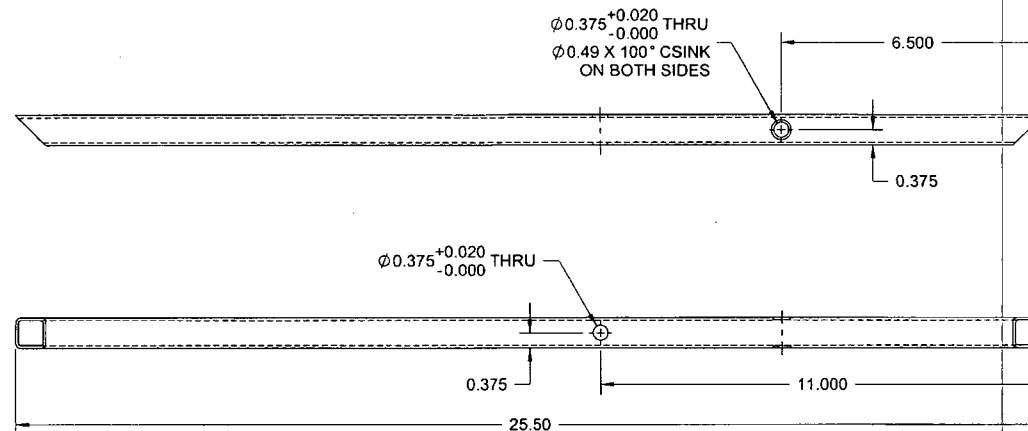
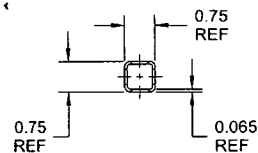
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NOTE: Date & initial all entries



D3825-1 RIB

u/b 70426

RELEASED
08/11/13

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.18 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3825	REV. A
MFG. APPR.			SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET END)	NTS
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